

Duplicate

Dart Aerospace Ltd.

Date: Thursday, 6/21/2007 8:27:50 AM
User: Chantal Lavoie









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Job Number : 32285	
Estimate Number : 11174	
P.O. Number : <i>N/A</i>	Part Number : D3290041
This Issue : 6/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3290 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 5/10/2007 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28649	Material : <i>N/A</i>
Written By : _____	Due Date : 6/6/2007 Qty: 6 Um: Each
Checked & Approved By : _____	
Comment : Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
		
	Comment: Qty.: 3.9375 sf(s)/Unit Total : 23.6250 sf(s) 5052-H32 .040 Sheet (M5052H32S040) Batch: 052264	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <i>B</i> Prog Rev: _____ 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 8:27:50 AM
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Job Number: 32285

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N/A
258' only

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 39.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description
1 D2126-0780 Locking Seal

Batch

B23077(1)

B32619(5)

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description
1 D3290-1 Window Frame

Batch

B27566(5X)

B26932(1X)

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Window

Pick:

Qty Part Number Description
1 D3290-3 Window

Batch

B29568

Effort 6/21/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *Q* Date: 07/06/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 07/06/26 (6)

SAD 07/06/26 (6)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

June 26

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5/272

EP 07/06/27 (6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6)
07/06/27

Job Completion



U 07.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

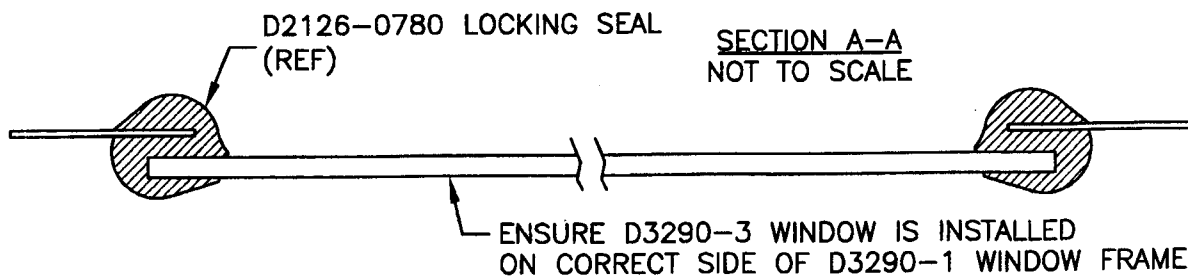
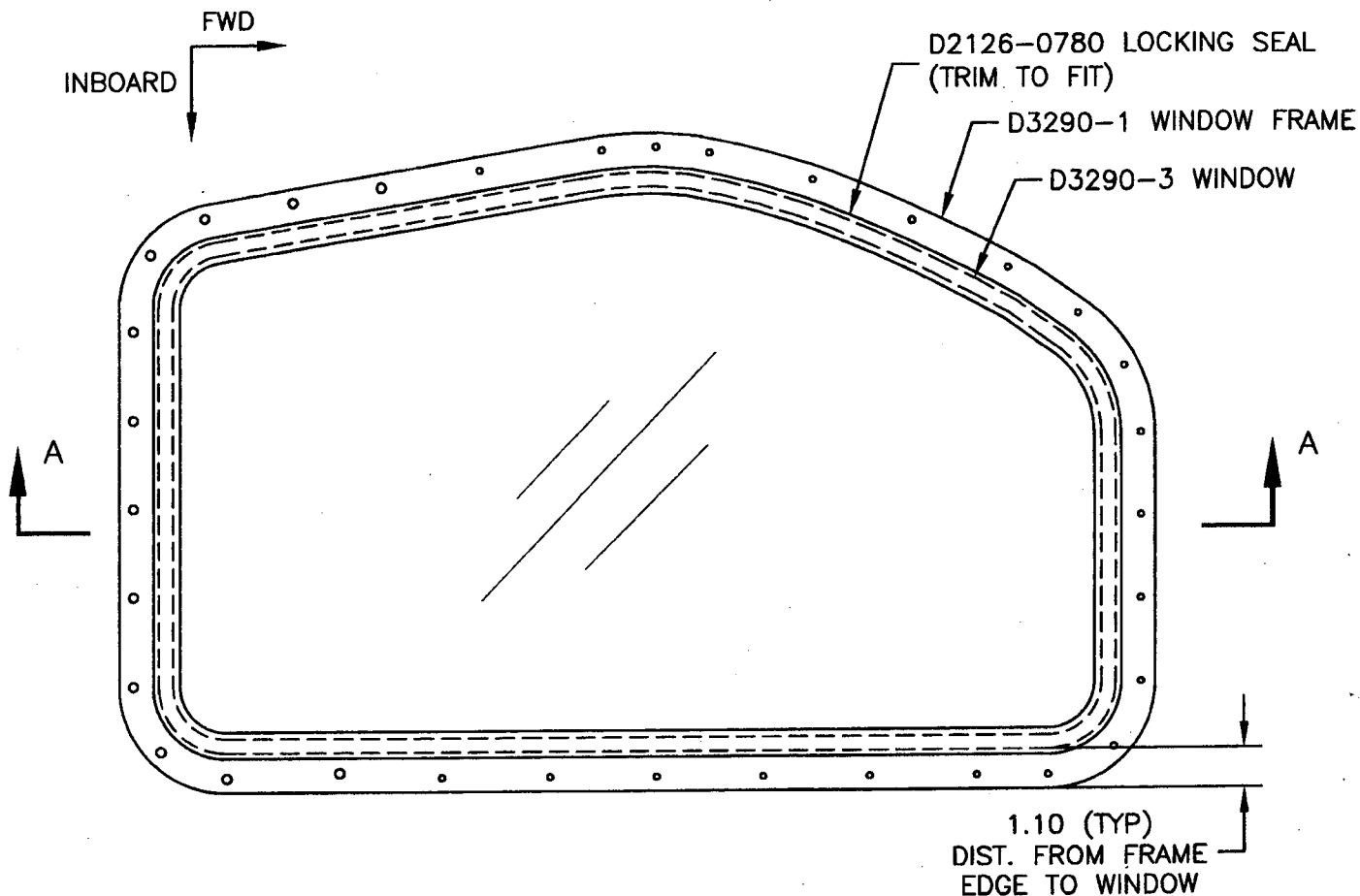
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	

**D3290-041****NOTES**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




RELEASED
06.04.20 *[Signature]*

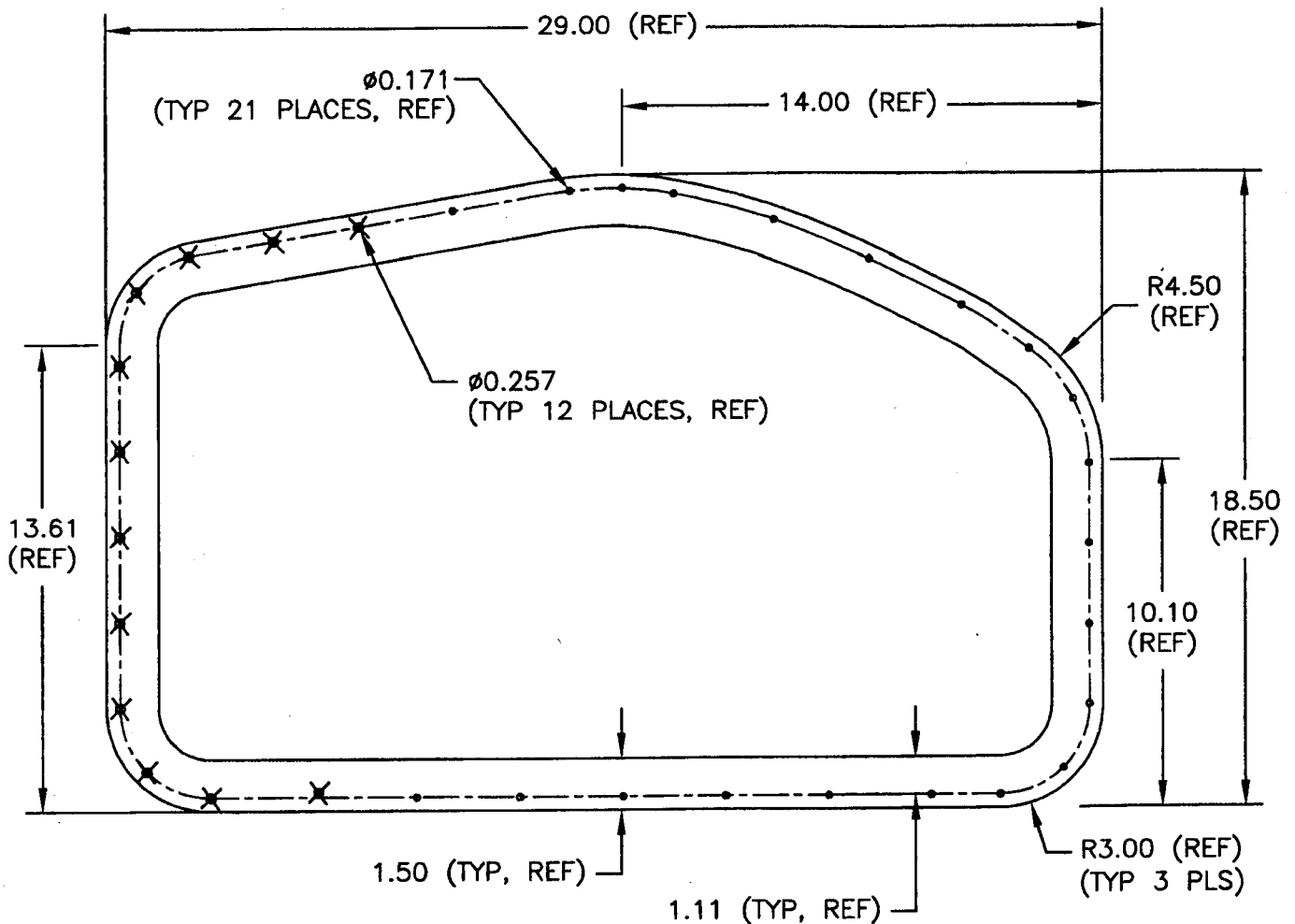
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C207/06/21
W10 32285


DART

DESIGN RF	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

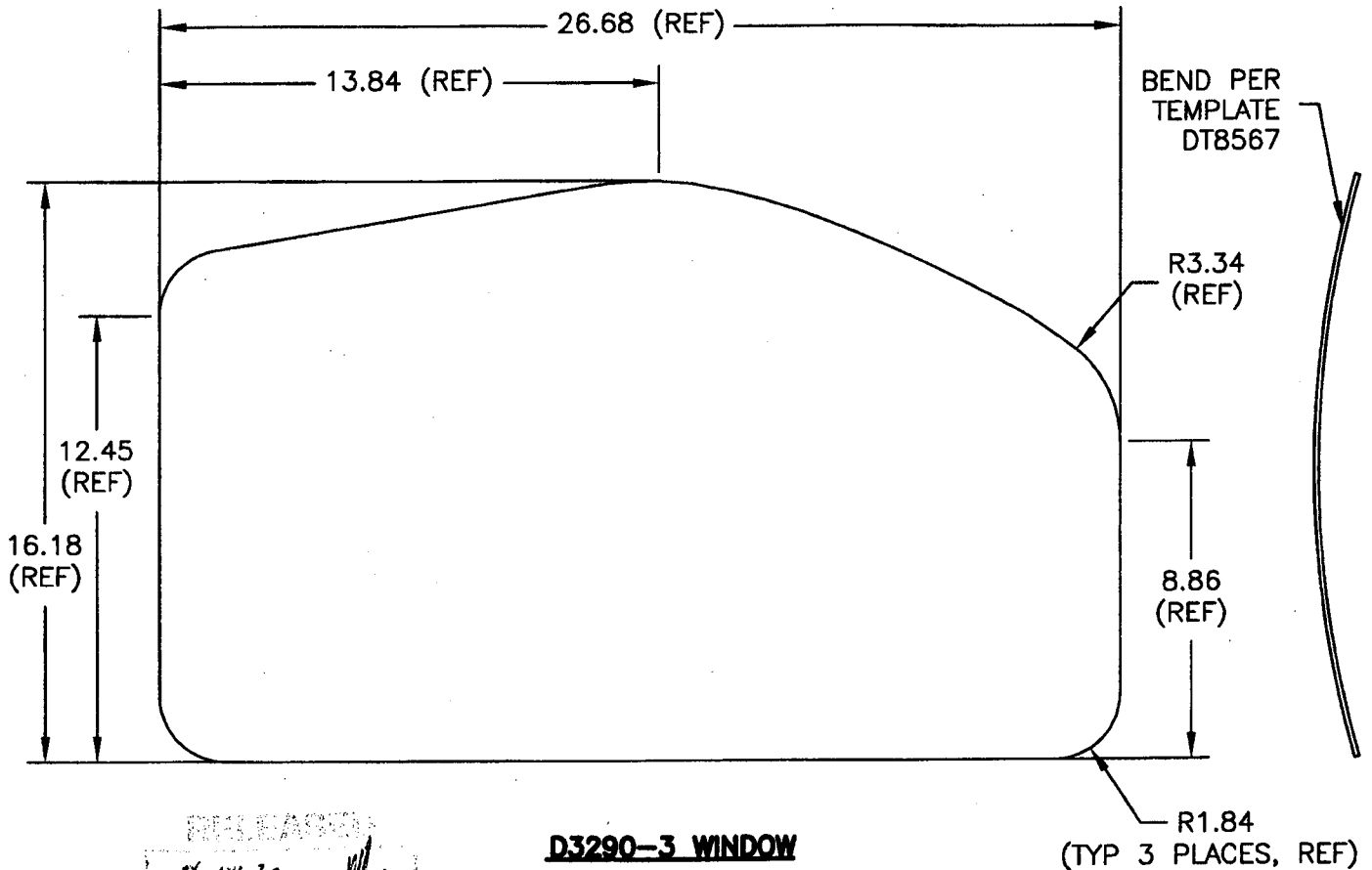
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0207/06/21
w/0 82285

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



RELEASED
06.04.20 *[Signature]*

D3290-3

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

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0207/06/21

w/o 32285